

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000685**Date Inspected:** 19-Oct-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai,China

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|------------------------------------|---------|---------------------|----------------|----------------------------------|-----|----|-----|
| CWI Name: | N/A | CWI Present: | Yes | No | | | |
| Inspected CWI report: | Yes | No | N/A | Rod Oven in Use: | Yes | No | N/A |
| Electrode to specification: | Yes | No | N/A | Weld Procedures Followed: | Yes | No | N/A |
| Qualified Welders: | Yes | No | N/A | Verified Joint Fit-up: | Yes | No | N/A |
| Approved Drawings: | Yes | No | N/A | Approved WPS: | Yes | No | N/A |
| | | | | Delayed / Cancelled: | Yes | No | N/A |
| Bridge No: | 34-0006 | Component: | Plate Material | | | | |

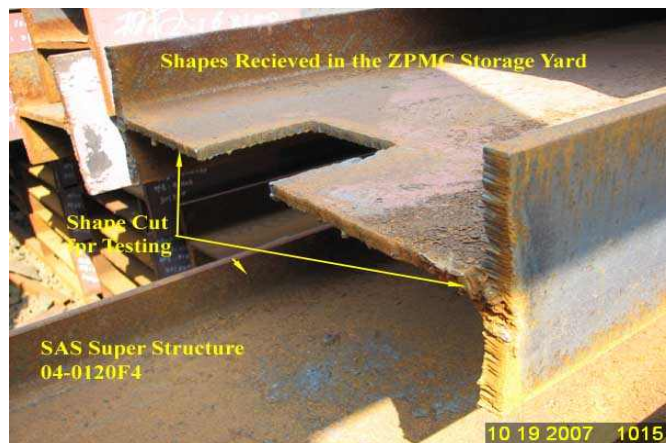
Summary of Items Observed:

Caltrans Quality Assurance (QA) Inspector Timothy McClendon arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island in Shanghai, China to periodically monitor welding and Quality Control (QC) functions. While on site the QA Inspector observed and/or discovered the following at the Plate Material Storage Yard:

QA Inspector Timothy McClendon received shapes material list for batch #1, production list No. 1 ~ 10 from American Bridge/Fluor (ABF) with a total of 635 pieces. QA Inspector Timothy McClendon went to the ZPMC material storage yard accompanied by ZPMC QA Mr. Eric Xu Jun and ZPMC QC Miss Cary Wu Min. QA Inspector Timothy McClendon randomly inspected shapes for overall condition and markings. Shape sizes were W21 x 57 and W920 x 310 x 201. The plates were designated as A709 GR.50. QA Inspector Timothy McClendon compared information on shape list against markings on shapes no discrepancies were discovered with only light surface corrosion found and standing water on one W21 x 57 shape. However, QA Inspector Timothy McClendon did notice the ends of several shapes were flame cut and/or material missing. Shape material list for batch #1 was accompanied with Material Test Reports (MTR). The MTR's could not be reviewed on this date and will be reviewed at the earliest opportunity. QA Inspector Timothy McClendon assigned lot number B94-004-07 to the shapes observed on this date.

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Summary of Conversations:

QA Inspector Timothy McClendon questioned American Bridge/Fluor (ABF) representative Mr. Jeff Evins about protecting the shapes from excess corrosion. Mr. Jeff Evins explained to QA Inspector Timothy McClendon after receiving Inspection was complete shapes would be moved to blast and paint yard for the application of the first coat of the painting process. After this first "Primer" coat is applied the heat numbers will be stamped for identification so shapes may be cut down the center of the web in order to make tee's. An additional conversation with ZPMC QC Mr. Eric Xu Jun stated because the shapes are stored in a manner that 100% visual inspection was impractical. ZPMC will provide Caltrans QA Inspectors the opportunity for additional inspection once shapes are separated in blast/paint yard and before blasting operation has started. Also, QA Inspector Timothy McClendon questioned ZPMC QA Mr. Eric Xu Jun as to why the ends of shapes were flame cut and material was missing. ZPMC QA Mr. Eric Xu Jun informed QA Inspector Timothy McClendon material was removed for testing purposes.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

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Inspected By: McClendon, Timothy

Quality Assurance Inspector

Reviewed By: Cuellar, Robert

QA Reviewer